

Work Order ID 76263

Tuesday, November 08, 2011 1:23:31 PM

76263

Page 1

Item ID: D3646-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 11/8/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/08 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3646 | Rev <u>PC</u> | | | | | | | | |

100
100 NC BRAKE
 Brake NC
 Brake NC
 Memo
 1-Punch to length as per Dwg D3646 & template DT8958
 24.800 cut → FF 12-01-26
 0.00
 0.00
 FF 12-01-31
 (8)

110
110 Small Fab
 Small Fab
 Small Fab
 Memo
 1-Deburr
 0.00
 0.00
 FF 12-01-31
 (8)

120
120 QC5- Inspect part completeness to step on W/O
 QC
 Quality Control
 Memo
 0.00
 0.00
 (XE)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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 Required Date: 11/22/2011 Req'd Qty: 8.00 ***8*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | START TIME: 9:30 OVEN TEMPERATURE: 320°F FINISH TIME: 10:00 | | | | | | | | |
| 140 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | Identify as per dwg & Stock Location: 229 | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

8X0M/12/02/03

8 BX 12-22

612/44 8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Work Order ID 76263***76263***

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Item ID: D3646-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 11/8/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

M.L.J 12/02/06 12/20/24
(4)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Tuesday, November 08, 2011 1:23:37 PM

Work Order ID: 76263

76263

Parent Item: D3646-1

D3646-1

Parent Item Name: Arm

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev. A new issue 07.07.25 EC verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TR0.500W.035 | | Purchased | No | | | 100 | f | 155.6323 | 1.98 | 16.67368 | | | |

M304TR0 500W 035

304 RD Tube .500 x .035W

Location

Loc Qty

Loc Code

MAT017

155.6322723

115535

2.33

116720

1.66068

117598

16.6415923

118702

35

119160

100

119644

FF 12-01-26

(8)

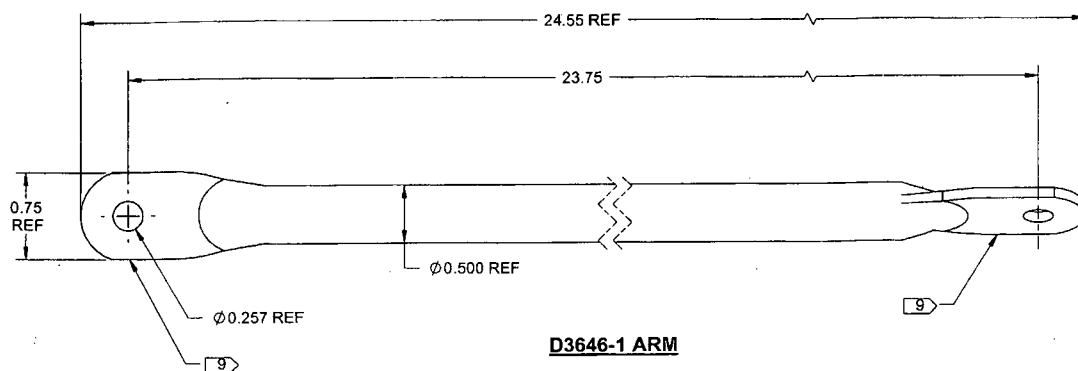
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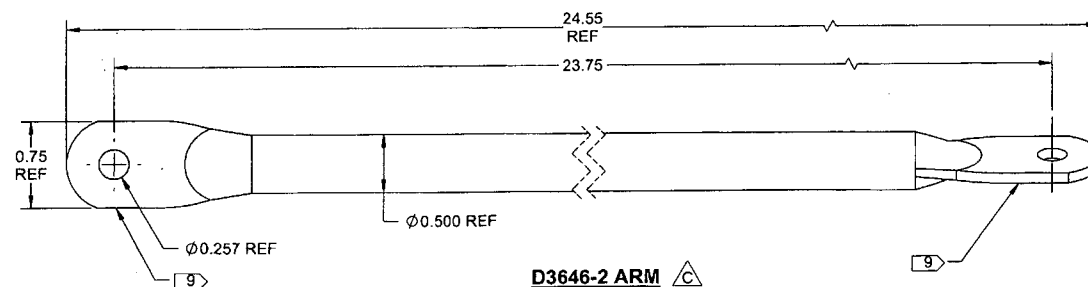
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NOTE: Date & initial all entries



D3646-1 ARM



D3646-2 ARM

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDING" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) DELETED AT REV. C
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 7626-3

RELEASED
2011-07-12

| C | ADD-2 & -4 FOR LHS INSTALLATION. DELETE REFERENCES TO TEMPLATES (NOTE 8) PER SHOP REQUEST. | AJS | 11.07.11 |
|------------|--|---|----------|
| B | REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN A8-1, A8-2) | CP | 09.06.04 |
| A | NEW ISSUE | MB | 07.06.06 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3646 TITLE ARM SHEET 1 OF 3 SCALE NTS COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DRAWN | AJS | | |
| CHECKED | MB | | |
| MFG. APPR. | MB | | |
| APPROVED | MB | | |
| DE APPR. | MB | | |
| DATE | 11.07.11 | | |

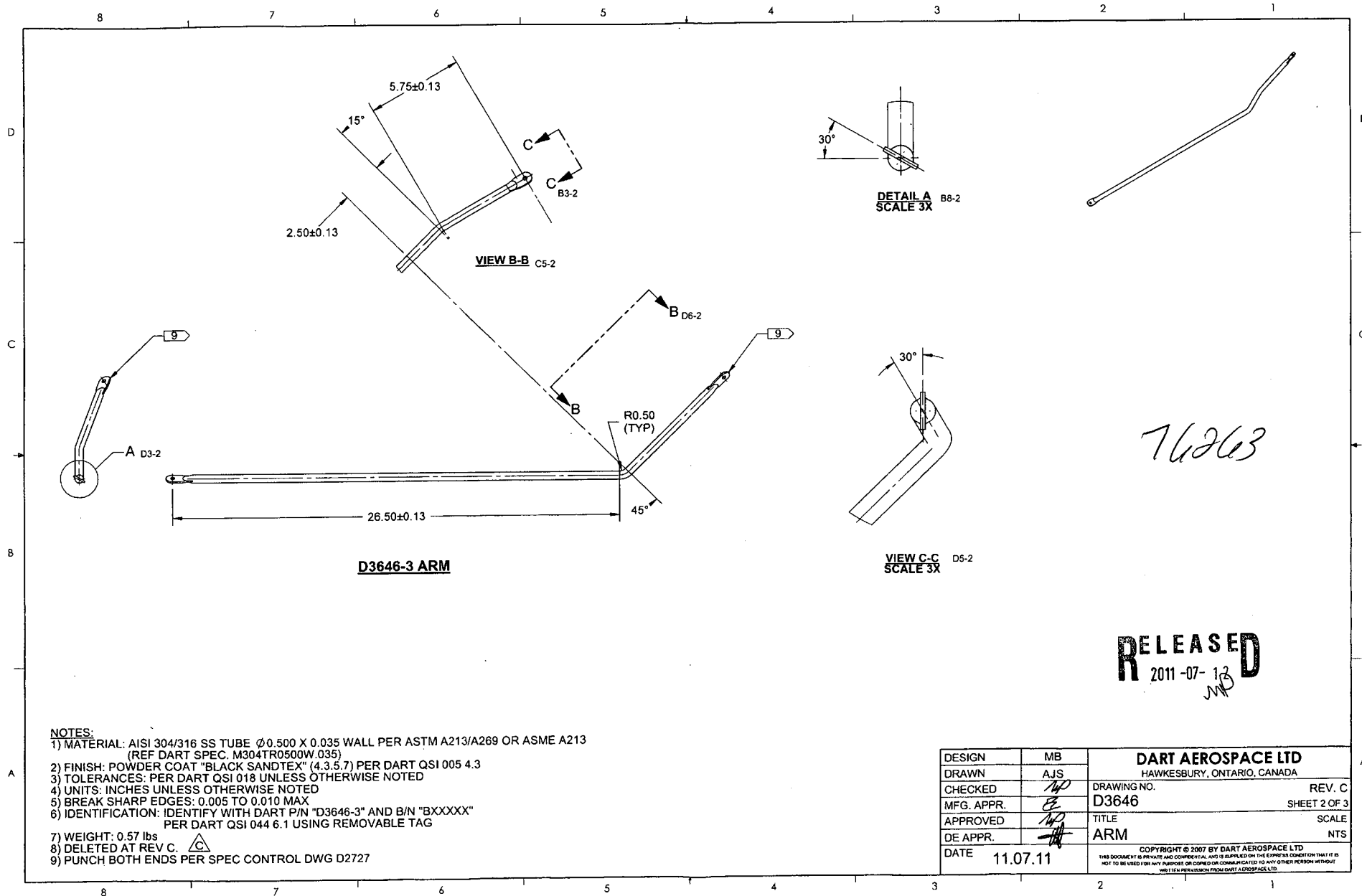
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NOTE: Date & initial all entries



RELEASED
2011-07-13
JMB

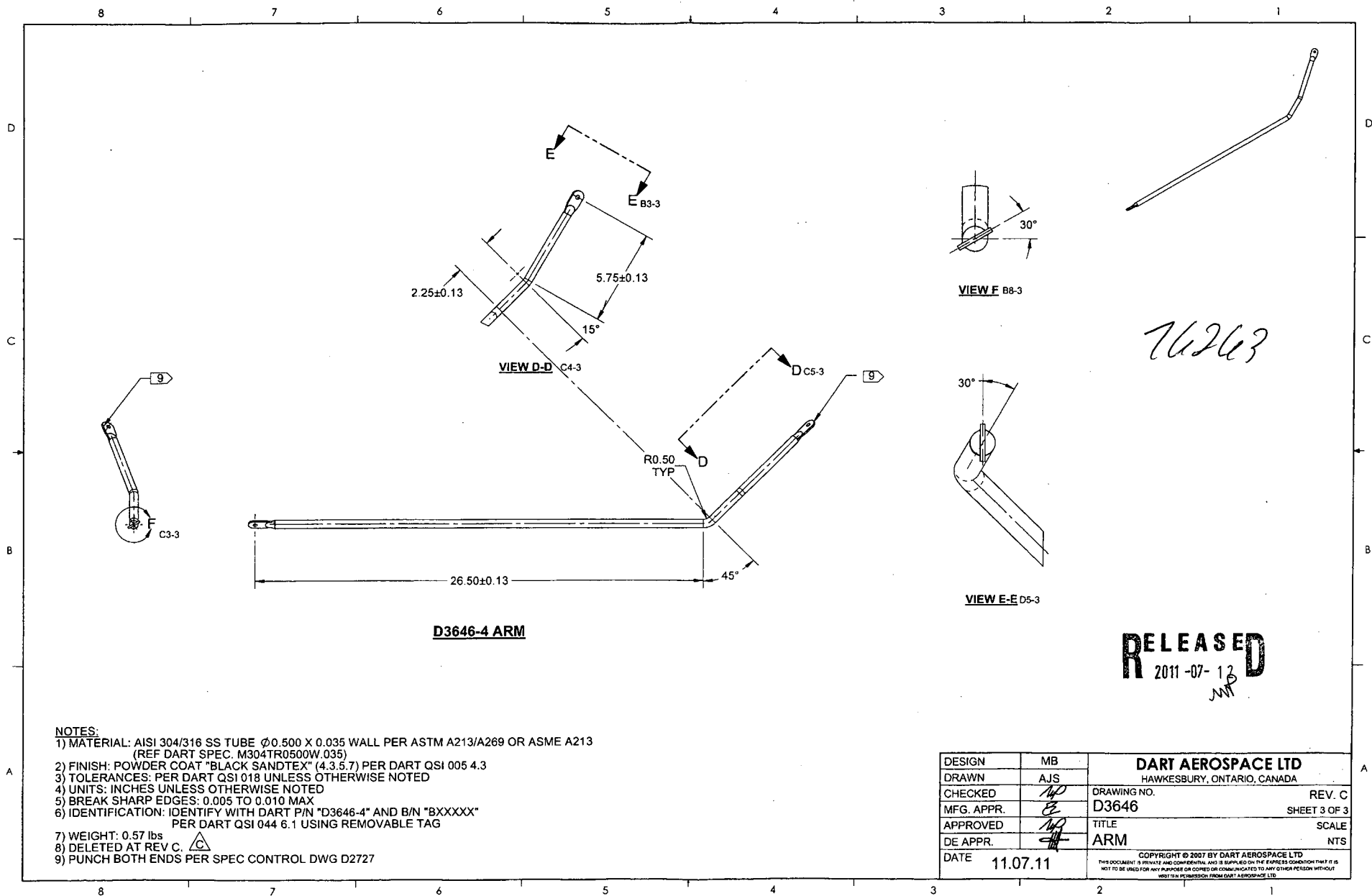
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